

MULTIPURPOSE SOLUBLE COOLANT**IPOL AQUACUT 125****Description :**

IPOL AQUACUT 125 is a Multi purpose water soluble coolant giving milky white stable emulsion. The product is designed for machining and grinding of ferrous as well as non ferrous materials. The product is formulated with highly refined base oil fortified with good quality emulsifier, corrosion inhibitors and other performance additive package. The product is operator friendly and gives satisfactory performance in terms of quality of machining operation and life of the product with proper maintenance.

Salient Features:

- Milky stable emulsion.
- Good lubricity
- Good corrosion Resistance.
- Forms stable emulsion at 400 ppm of hardness of water.
- Multipurpose use.
- Highly economical.
- Operator friendly.
- Suitable for stand alone as well as centralized coolant systems.

Application:

- Recommended for machining of Aluminium in Central Systems and for light duty machining and grinding of Ferrous materials.
- Suggested concentration 6 to 7% for Aluminium machining and about 5% for ferrous machining.
- Advisable to use with water hardness of 100 to 200 ppm for optimum performance.
- For long life Cl and S should be less than 50 PPM in water.

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Coolant Management Guidelines :

- Ensure that before charging an emulsion the machines are clean.
- While preparing the emulsion always add oil to water. While addition, the agitator must be on. Never add water to oil.
- Check the emulsion concentration on regular basis. Maintenance of proper concentration gives satisfactory performance as well as minimize bacteria problem.
- The top up should be done in the form of emulsion. Never add only water or oil to the sump.
- Periodical checking of Bacterial count needs to be done. The earlier detection of bacterial count can be tackled easily by using proper additives.

Typical Results : IPOL AQUACUT 125

Characteristic	Test Method	Results
Colour	ASTM D 1500	Brownish Clear
Specific Gravity @ 30 °C	ASTM D 1298	0.896
PH value 5 % emulsion	IPOL Standard	9.4
Nature of Emulsion	Visual	Milky Emulsion
Emulsion Stability 5 % in DM Water	Is 1448 P - 98/99	Passes
Emulsion Stability 5 % in 400 ppm Water	Is 1448 P - 98/99	Passes
Cast Iron corrosion 3 % in 400ppm Water	IS 1115	Passes
Frothing stability @ 200 ppm water	IS 1115	Passes

Note: The information provided is not to be taken as a warranty or representation for which we assume no legal responsibility nor as permission or recommendation to practice any attended location or otherwise. It is solely offered for your consideration, investigation and verification.

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Sah Petroleums Limited

406/407, Embassy Centre, Nariman Point, Mumbai – 400 021, India. Tel: +91 22 66301911, Fax: +91 22 22875751.
Email Id: ipol@sahpetroleums.com Website: www.sahpetroleums.com

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